

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007987**Date Inspected:** 20-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia, Yu Dong Pin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY YARD**SEGMENT 3AW-3BW****Visual Inspection**

During the random Visual Inspection this Quality Assurance inspector (QA) observed the contractors welding personnel perform SPCM Critical Weld Repairs (CWR) on the OBG segment 3AW the hold back area of the weld SEG021-001-127 at PP21-FL03 without an approved CWR procedure. The repair area was excavated to a depth that exceeded 65% of the material thickness. The thickness of the base material was measured at 14mm and the excavation was measured at more than 10mm deep after root pass had been welded. For this issue the incident report was issued.

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 6A located on PCMK ND1-A6003-7. Welder is identified as 040460 ZPMC QC is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS-B-T-4221-B-U3C-S-1.

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FCAW welding process of weld joint 33 located on PCMK NSD1-TL8K/L. Welder is identified as 040338 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-2.

FCAW welding process of weld joint 37 located on PCMK NSD1-TL8K/L. Welder is identified as 054069 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-2.

FCAW welding process of weld joint 30 located on PCMK NSD1-TL8K/L. Welder is identified as 057244 ZPMC QC is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2A-F-2.

BAY#11

SAW welding process of weld joint 29B located on PCMK WSD1-FCSA4-2A/C Welder is identified as 047304 ZPMC QC is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S-2.

TRIAL ASSEMBLY YARD

This QA Inspector observed ZPMC performing Plug welding for miss drill hole of a top rib at FL3 of segment 3BW-3AW at PP22.

This QA Inspector observed ZPMC personnel installed bolt and snug tightening in progress on floor beam to bottom palate clip at PP25 in segment 4AW south section.

This QA Inspector observed ZPMC personnel installed bolt and snug tightening in progress on floor beam to bottom palate clip at PP20 in segment 3AW south section.

This QA Inspector observed ZPMC NDT Technician was performing Magnetic particle testing on the weld joint between 'T' stiffeners to bottom panel at PP18.5 in segment 2BE north section.

This QA Inspector observed ZPMC NDT Technician was performing Magnetic particle testing on the weld joint between side panel stiffeners to floor beam at PP11 in segment 2BW north section.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
